

Date: Tuesday, 08/01/2008 3:19:44 PM  
 User: Jean-Luc Menard

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: 03.250 SUPPORT		
Job Number	: 35582 -2			Part Number	: D29401		
Estimate Number	: 10387			Drawing Number	: D2940 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 08/01/2008 S.O. No. :			Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: 06/11/2007 Type : MACHINED PARTS			Due Date	: 13/12/2007		
Previous Run	: 35478			Qty:			
Written By	<i>JLM</i>			Um:	Each		
Checked & Approved By				32			
Comment	: Est. C 02.11.26 Reformat; Added P/O KJ Est Rev:D Added priming as per Rev B 07-04-30 JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	D6104007	17-4 SS Roundbar 4.50"OD	
		Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s) 17-4 SS Roundbar 4.50"OD 35478 X 8	
		D6104-007 BATCH: 35582A	
2.0	35582A	ROUND BILLET 17-4	
		Comment: Sub-Component ROUND BILLET 17-4 D6104-007 B	
3.0	DOOSAN LATHE	DOOSAN LATHE	
		Comment: Doosan Turn blank for Haas as per Folio FA079	20 08/01/08
4.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	20 08/01/08 20
5.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS 1- Machine as per Folio FA079 2- Tumble & Deburr	20 08/01/08 20

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 03.250 SUPPORT

Job Number: 35582

Part Number: D29401

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 QC1

INSPECT ALL DIM TO DIM SHEET



16

Comment: INSPECT ALL DIM TO DIM SHEET

mkl / 29/JL 08/04/09 ⑧

7.0 QC8

SECOND CHECK



16 ⑧

Comment: SECOND CHECK

Aut 08.04.09

8.0 POWDER COATING

POWDER COATING



⑧X

M 107550



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

\*\*\*\*\*Mask Inside Surface as per Dwg D2940\*\*\*\*\*

m-l

16 08/04/11

9.0 SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

m 08 04 14

⑧ 16

Prime inside surface as per Dwg D2940 and QSI 005 4.3.

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PT 08 - 04 - 15 ⑮

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

m 08 04 15

⑧ 16

12.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/16 AJ

Job Completion



mk 08-04-16

T AEROSPACE LTD

Work Order:

35582

Description: Ø3.250 Support

Part Number:

D2940-1

Inspection Dwg: D2940 Rev. B

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. B / DSK081 Rev. B &amp; record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
<b>Lathe Section</b>									
A	3.211	3.216		3.215	3.215	3.215	3.215		
B	4.946	4.966		4.956	4.956	4.956	4.956		
C	0.718	0.738		0.726	0.726	0.726	0.726		
D	0.090	0.110		0.102	0.102	0.102	0.102		
E	3.564	3.584		3.574	3.574	3.574	3.574		
F	0.022	0.042		0.03	0.03	0.03	0.03		
G	3.444	3.464		3.454	3.454	3.454	3.454		
H	0.112	0.132		0.122	0.122	0.122	0.122		
I	2.170	2.190		2.18	2.18	2.18	2.18		
J	4.451	4.471		4.461	4.461	4.461	4.461		
K	0.413	0.433		0.423	0.423	0.423	0.423		
L	0.913	0.933		0.923	0.923	0.923	0.923		
M									
N									
<b>HAAS Section</b>									
AA	0.240	0.260		0.250	0.250	0.250	0.250		
AB	0.490	0.510		0.500	0.500	0.500	0.500		
AC	0.140	0.160		0.150	0.150	0.150	0.150		
AD	3.510	3.530		3.514	3.525	3.525	3.525		
AE	1.633	1.673		1.642	1.652	1.652	1.652		
AF	1.493	1.513		1.497	1.502	1.502	1.502		
AG	0.040	0.060		0.051	0.050	0.050	0.050		
AH	0.188	0.193		0.188	0.188	0.188	0.188		
AI	0.140	0.160		0.148	0.153	0.153	0.153		
AJ	2.518	2.538		2.530	2.530	2.530	2.530		
AK	0.040	0.060		0.051	0.051	0.051	0.051		
AL	0.010	0.020		0.015	0.015	0.015	0.015		
AM	0.140	0.160		0.154	0.154	0.154	0.154		
AN	0.350	0.450		0.355	0.355	0.355	0.355		
AO	0.240	0.260		0.250	0.250	0.250	0.250		
AP	0.150	0.170		0.150	0.154	0.154	0.154		
AQ	0.053	0.073		0.063	0.063	0.063	0.063		
AR	101.64	105.64		103.64	103.64	103.64	103.64		
AS	0.260	0.267		0.260	0.266	0.266	0.266		
AT	0.053	0.073		0.063	0.063	0.063	0.063		
AU	4.118	4.138		4.123	4.126	4.127	4.126		
AV									

**Accept/Reject**

Measured by:	<i>JK</i>	<i>JK</i>
Date:	<i>07/07/08</i>	<i>07/07/08</i>

Audited by:	<i>JK</i>
Date:	<i>08.07.08</i>

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM <i>JK</i>	<i>EE</i>

AEROSPACE LTD

Work Order: 35582

Description: Ø3.250 Support

Part Number: D2940-1

Inspection Dwg: D2940 Rev. B

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. B / DSK081 Rev. B &amp; record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
<b>Lathe Section</b>									
A	3.211	3.216		3.215	3.215	3.217	3.215		
B	4.946	4.966		4.956	4.955	4.956	4.955		
C	0.718	0.738		0.725	0.725	0.727	0.725		
D	0.090	0.110		0.091	0.092	0.093	0.093		
E	3.564	3.584		3.574	3.575	3.578	3.575		
F	0.022	0.042		0.03	0.03	0.02	0.02		
G	3.444	3.464		3.457	3.457	3.458	3.457		
H	0.112	0.132		0.121	0.122	0.127	0.125		
I	2.170	2.190		2.18	2.18	2.18	2.18		
J	4.451	4.471		4.461	4.461	4.463	4.460		
K	0.413	0.433		0.421	0.423	0.423	0.423		
L	0.913	0.933		0.923	0.923	0.923	0.923		
M									
N									
<b>HAAS Section</b>									
AA	0.240	0.260							
AB	0.490	0.510							
AC	0.140	0.160							
AD	3.510	3.530							
AE	1.633	1.673							
AF	1.493	1.513							
AG	0.040	0.060							
AH	0.188	0.193							
AI	0.140	0.160							
AJ	2.518	2.538							
AK	0.040	0.060							
AL	0.010	0.020							
AM	0.140	0.160							
AN	0.350	0.450							
AO	0.240	0.260							
AP	0.150	0.170							
AQ	0.053	0.073							
AR	101.64	105.64							
AS	0.260	0.267							
AT	0.053	0.073							
AU	4.118	4.138							
AV									
<b>Accept/Reject</b>									

Measured by:

Date:

Audited by:

Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	EE

AEROSPACE LTD

Work Order:

35582

Description: Ø3.250 Support

Part Number:

D2940-1

Inspection Dwg: D2940 Rev. B

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. B / DSK081 Rev. B &amp; record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1"	1 1/16"	3 11/16"	4 1/2"	By	Date
<b>Lathe Section</b>									
A	3.211	3.216		3.215	3.215	3.215	3.215		
B	4.946	4.966		4.956	4.956	4.956	4.956		
C	0.718	0.738		.732	.734	.725	.727		
D	0.090	0.110		.102	.102	.103	.102		
E	3.564	3.584		3.574	3.574	3.574	3.574		
F	0.022	0.042		.03	.03	.03	.03		
G	3.444	3.464		3.454	3.454	3.454	3.454		
H	0.112	0.132		.122	.122	.122	.122		
I	2.170	2.190		2.18	2.18	2.18	2.18		
J	4.451	4.471		4.461	4.461	4.461	4.461		
K	0.413	0.433		.423	.423	.423	.423		
L	0.913	0.933		.923	.923	.923	.923		
M									
N									
<b>HAAS Section</b>									
AA	0.240	0.260		.250	.250	.250	.250		
AB	0.490	0.510		.500	.500	.500	.500		
AC	0.140	0.160		.152	.151	.151	.151		
AD	3.510	3.530		3.522	3.522	3.524	3.523		
AE	1.633	1.673		1.664	1.659	1.656	1.655		
AF	1.493	1.513		1.506	1.501	1.502	1.498		
AG	0.040	0.060		.050	.053	.050	.051		
AH	0.188	0.193		.188	.188	.188	.188		
AI	0.140	0.160		.152	.153	.146	.147		
AJ	2.518	2.538		2.530	2.530	2.536	2.530		
AK	0.040	0.060		.050	.051	.050	.049		
AL	0.010	0.020		.015	.015	.015	.015		
AM	0.140	0.160		.149	.148	.148	.148		
AN	0.350	0.450		.360	.360	.360	.360		
AO	0.240	0.260		.250	.250	.250	.250		
AP	0.150	0.170		.158	.155	.157	.156		
AQ	0.053	0.073		.063	.063	.063	.063		
AR	101.64	105.64		103.64	103.64	103.64	103.64		
AS	0.260	0.267		.260	.260	.260	.260		
AT	0.053	0.073		.063	.063	.063	.063		
AU	4.118	4.138		4.124	4.124	4.127	4.127		
AV									
<b>Accept/Reject</b>									

Measured by: *RJ* / JL / gwh  
 Date: 05/05/09 / 08/04/08

Audited by: *JL*  
 Date: 08.04.09

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM <i>JK</i>	<i>EZ</i>

AEROSPACE LTD

Work Order:

35582

Description: Ø3.250 Support

Part Number:

D2940-1

Inspection Dwg: D2940 Rev. B

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. B / DSK081 Rev. B &amp; record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1/3	2 1/4	3 1/5	4 1/6	By	Date
<b>Lathe Section</b>									
A	3.211	3.216		4.956	7.986	7.956	7.956		
B	4.946	4.966		.754	.722	.727	.728		
C	0.718	0.738		.102	.102	.102	.102		
D	0.090	0.110		.102	.102	.102	.102		
E	3.564	3.584		3.574	3.574	3.574	3.574		
F	0.022	0.042		.03	.03	.03	.03		
G	3.444	3.464		3.454	3.454	3.454	3.454		
H	0.112	0.132		.122	.122	.122	.122		
I	2.170	2.190		2.188	2.188	2.188	2.188		
J	4.451	4.471		4.461	4.461	4.461	4.461		
K	0.413	0.433		.423	.423	.423	.423		
L	0.913	0.933		.923	.923	.923	.923		
M									
N									
<b>HAAS Section</b>									
AA	0.240	0.260		.250	.250	.250	.250		
AB	0.490	0.510		.500	.500	.500	.500		
AC	0.140	0.160		.150	.149	.150	.151		
AD	3.510	3.530		3.525	3.525	3.527	3.525		
AE	1.633	1.673		1.655	1.657	1.657	1.655		
AF	1.493	1.513		1.497	1.500	1.497	1.498		
AG	0.040	0.060		.050	.050	.050	.050		
AH	0.188	0.193		.188	.188	.188	.188		
AI	0.140	0.160		.148	.145	.146	.146		
AJ	2.518	2.538		2.528	2.527	2.528	2.528		
AK	0.040	0.060		.049	.050	.049	.052		
AL	0.010	0.020		.015	.015	.015	.015		
AM	0.140	0.160		.146	.147	.146	.146		
AN	0.350	0.450		.360	.360	.360	.360		
AO	0.240	0.260		.250	.250	.250	.250		
AP	0.150	0.170		.158	.158	.160	.158		
AQ	0.053	0.073		.063	.063	.063	.063		
AR	101.64	105.64		103.64	103.64	103.64	103.64		
AS	0.260	0.267		.260	.260	.260	.260		
AT	0.053	0.073		.063	.063	.063	.063		
AU	4.118	4.138		4.128	4.128	4.128	4.128		
AV									

**Accept/Reject**Measured by: *JK* *JK*  
Date: *6/16/09* *08/04/09*Audited by: *JK*  
Date: *08/04/09*

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM <i>JK</i>	<i>EE</i>

KT AEROSPACE LTD

Work Order:

35582

Description: Ø3.250 Support

Part Number:

D2940-1

Inspection Dwg: D2940 Rev. B

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. B / DSK081 Rev. B &amp; record below:

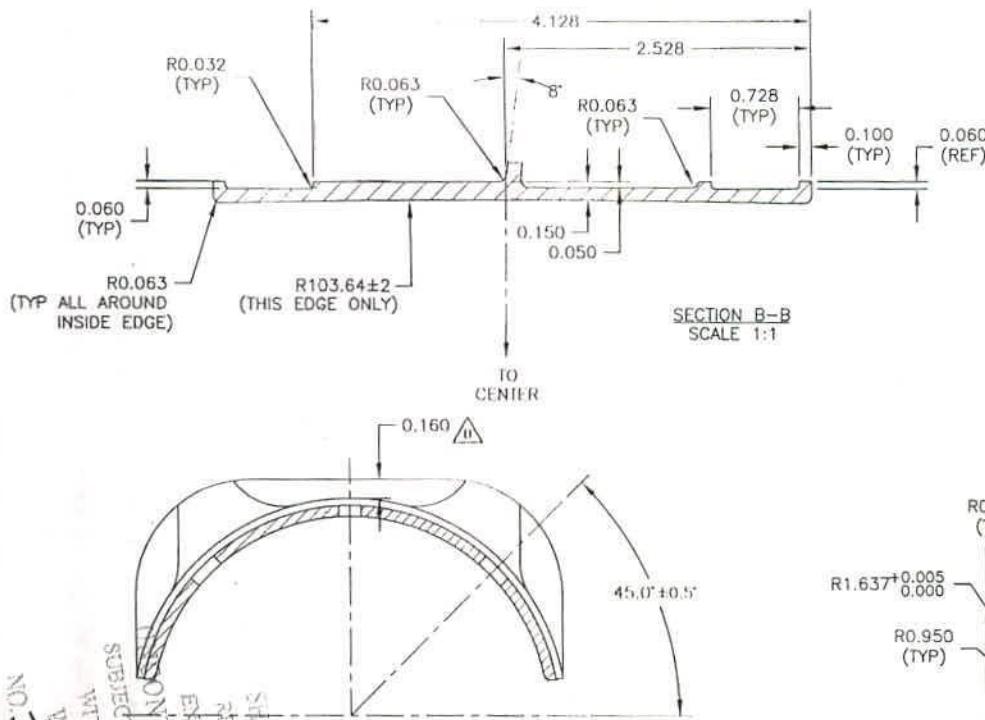
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1.17	2.18	3.19	4.20	By	Date
<b>Lathe Section</b>									
A	3.211	3.216		3.215	3.215	3.215	3.215		
B	4.946	4.966		4.954	4.954	4.954	4.954		
C	0.718	0.738		0.728	0.728	0.728	0.728		
D	0.090	0.110		0.092	0.092	0.092	0.092		
E	3.564	3.584		3.574	3.574	3.574	3.574		
F	0.022	0.042		0.03	0.03	0.03	0.03		
G	3.444	3.464		3.454	3.454	3.454	3.454		
H	0.112	0.132		0.122	0.122	0.122	0.122		
I	2.170	2.190		2.181	2.181	2.181	2.181		
J	4.451	4.471		4.461	4.461	4.461	4.461		
K	0.413	0.433		0.421	0.423	0.423	0.423		
L	0.913	0.933		0.923	0.923	0.923	0.923		
M									
N									
<b>HAAS Section</b>									
AA	0.240	0.260							
AB	0.490	0.510							
AC	0.140	0.160							
AD	3.510	3.530							
AE	1.633	1.673							
AF	1.493	1.513							
AG	0.040	0.060							
AH	0.188	0.193							
AI	0.140	0.160							
AJ	2.518	2.538							
AK	0.040	0.060							
AL	0.010	0.020							
AM	0.140	0.160							
AN	0.350	0.450							
AO	0.240	0.260							
AP	0.150	0.170							
AQ	0.053	0.073							
AR	101.64	105.64							
AS	0.260	0.267							
AT	0.053	0.073							
AU	4.118	4.138							
AV									
<b>Accept/Reject</b>									

Measured by: *RC*  
Date: *07/03/18*

Audited by:  
Date:

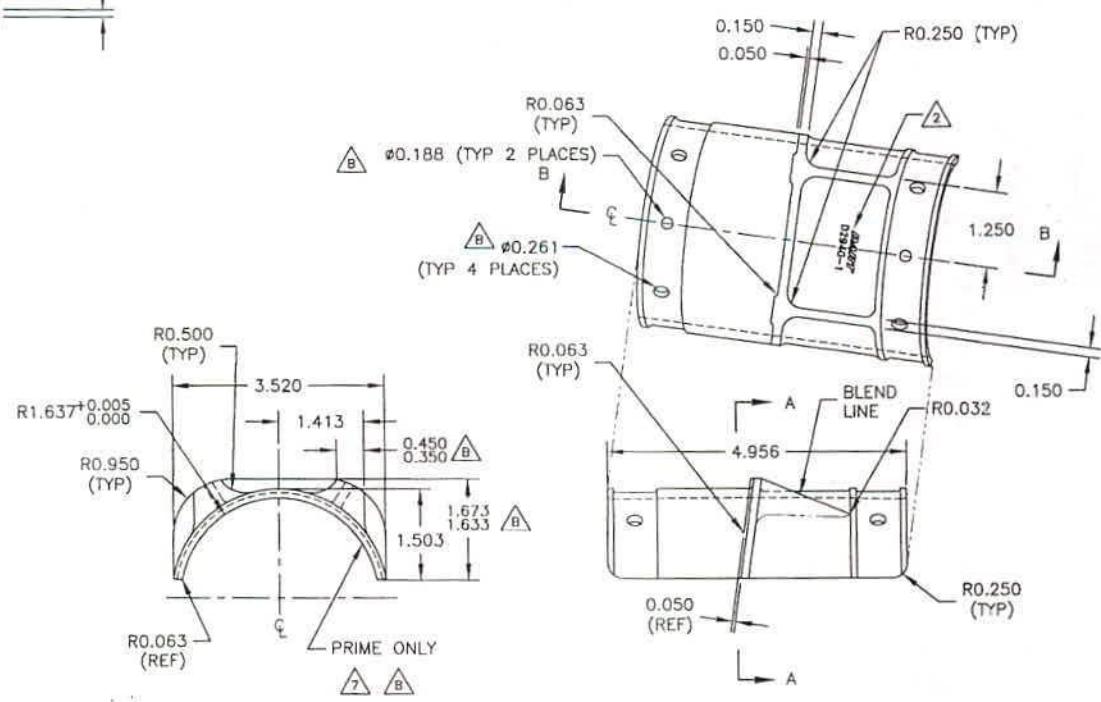
Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM <i>✓</i>	<i>EE</i>

RELEASED  
07.03.16 (P)  
PER D2940-1



NO. 2  
558  
D2940-1  
SHEET ONE OF ONE  
ENGINEERING DRAWING  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
CONTROLED COPY

- 1) MATERIAL: 17-4 PH STAINLESS STEEL  
HEAT TREAT TO H900 CONDITION  
(900°F FOR 1 HR, AIR COOL)  
MIN UTS = 170 KSI (38 HRc)
- 2) IDENTIFY WITH DART LOGO AND PART NUMBER IN THIS AREA  
WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3  
PRIME INSIDE SURFACE AS SHOWN PER DART QSI 005 4.2

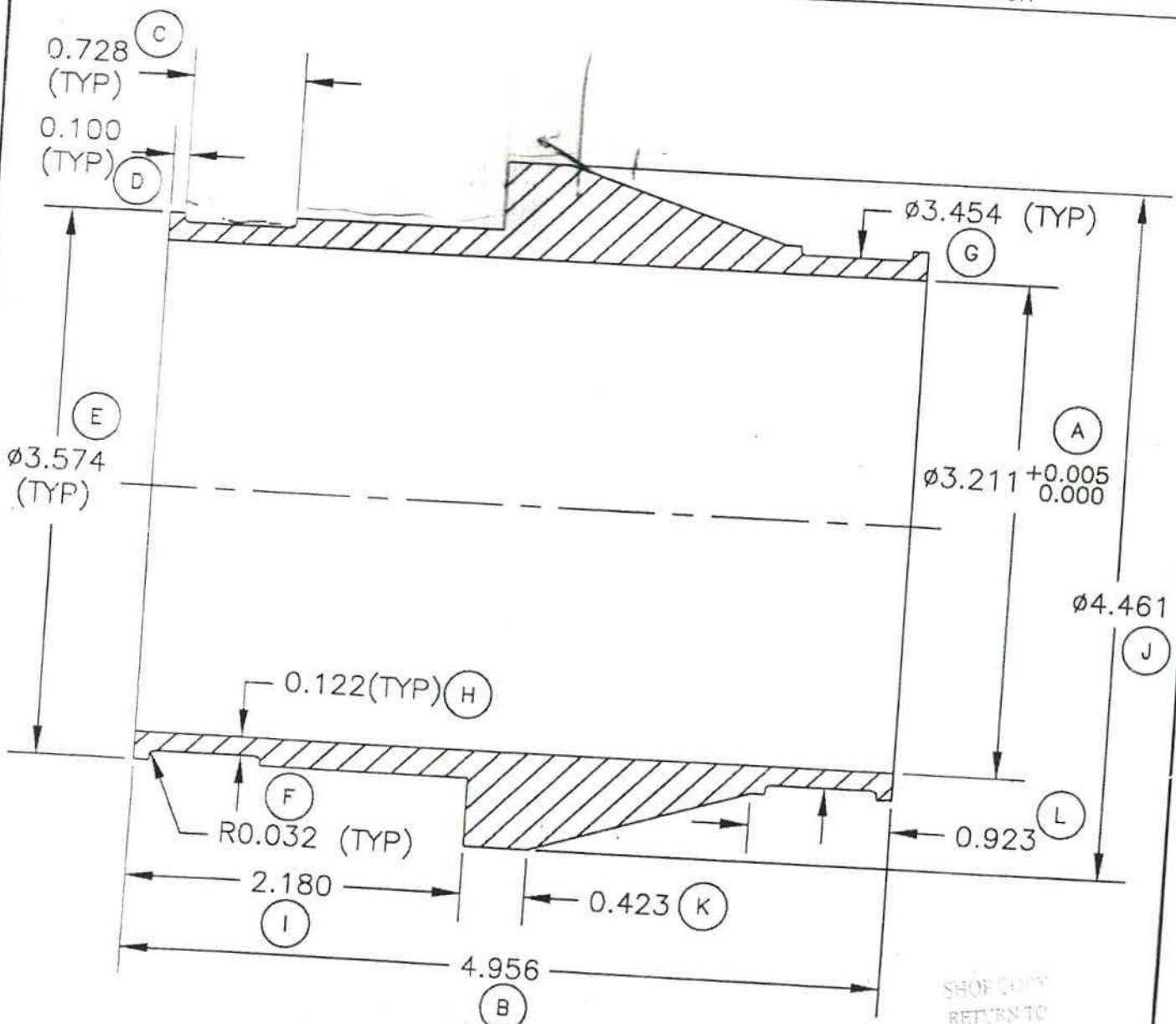


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THAT IT IS NOT TO BE USED FOR ANY PURPOSE  
OR COPIED OR COMMUNICATED TO ANY OTHER  
PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE LTD.

B	07.03.16	UPDATE PER NCR 642, PRIME INSIDE
A	01.01.10	NEW ISSUE
DESIGN	DRAWN BY	DART AEROSPACE LTD. HALIFAX, NS, CANADA
CHECKED	APPROVED	DRAWING NO. D2940 REV. B SHEET 1 OF 1
DATE	07.03.16	TITLE Ø3.250 SUPPORT SCALE 1:2

**DART**

DESIGN RF	DRAWN BY K	DART AEROSPACE LTD	
CHECKED H	APPROVED H	HAWKSLEY, ONTARIO, CANADA	
DATE 03.06.24		DRAWING NO. DSK 081	REV.
		TITLE TURNING DETAIL FOR D2940-1	SHEET 1 OF 1
A	03.03.07	SCAL	
B	03.06.24	1: ADDED 4.956 DIMENSION	



D2940-1 TURNING DETAIL